

Work Order ID 94685

December-19-12 2:51:56 PM

94685

Page 1

Item ID: D3535-35

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 12/19/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-20-12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

13 0 Jm 1-6-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

13 0 Jm 1-6-13

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

Quality Control

15
13.7

13 0 Jm 1-6-13

Work Order ID 94685

94685

Page 2

December-19-12 2:51:56 PM

Item ID: D3535-35 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 12/19/12 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 1/11/13 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00				13			8/13/06/23
Brake NC	Memo 1-Deburr if necessary 2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.3-Identify as D3535-35.	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				13			
Quality Control	Memo	0.00							
150 *150* Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				13			131-25
Powder Coating	Memo START TIME: 10:10 OVEN TEMPERATURE: FINISH TIME: 10:40	0.00							

Work Order ID 94685

December-19-12 2:51:56 PM

94685

Page 3

Item ID: D3535-35

Revision ID:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Item Name: Wearshoe

Start Date: 12/19/12 Start Qty: 12.00

Required Date: 1/11/13 Req'd Qty: 12.00

12

12

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

13x d M 13/01/28

170

170

Packaging

Packaging

Identify as per dwg & Stock Location FP-002

Memo

0.00

0.00

13 d 13-28.

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

13/1/28

13-01-28

Picklist Print

December-19-12 2:51:56 PM

Page 1

Work Order ID: 94685

Parent Item: D3535-35

Parent Item Name: Wearshoe

Start Date: 12/19/12

Required Date: 1/11/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	456.3001	0.8022	10.133053			
304/316 .040 Sheet											10.2	Jm, -6-13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		456.300065							
				121380		0.000065							
				122732		33							
				122753		103.3							
				124029		320							
									124029				

DART AEROSPACE LTD		Work Order:	946 FS
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000"	-		V	Jkm
1.885	+/-0.010	1.893"	-		V	
6.00	+/-0.030	6.004"	-		V	
6.75	+/-0.030	6.759"	-		V	
Ø0.188	+0.005/-0.001	0.189"	-		V	
23.250	+/-0.010	23.250"	-		T	Jkm
19.750	+/-0.010	19.750"	✓		T	
17.750	+/-0.010	17.750"	✓		T	
14.250	+/-0.010	14.250"	✓		T	
9.500	+/-0.010	9.507"	-		V	Product
4.750	+/-0.010	4.753"	-		V	
0.300	+/-0.010	0.303"	-		V	
0.300	+/-0.010	0.302"	-		V	
0.038	+/-0.010	0.036"	-		V	

Measured by:	Jm	Audited by:	SMA	Prototype Approval:	N/A
Date:	1-6-13	Date:	13/7	Date:	N/A

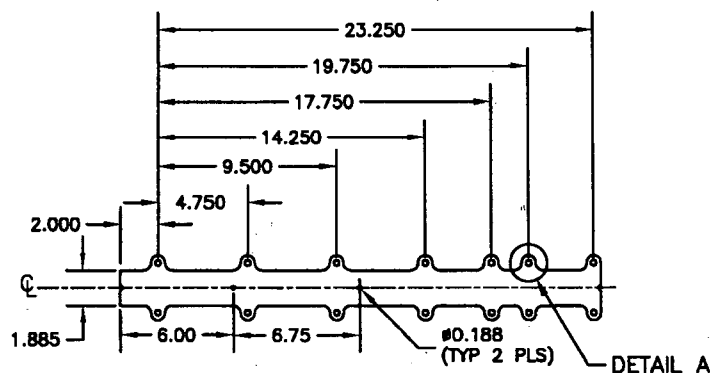
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

DART

RELEASED

07.04.17

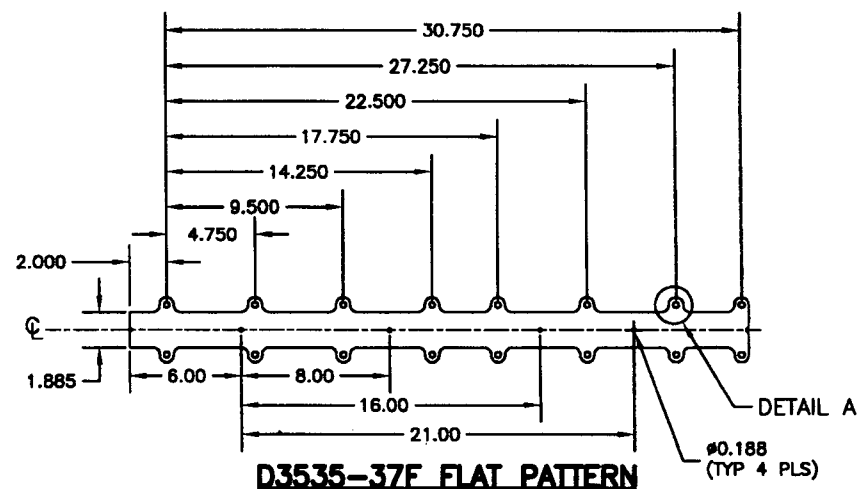
96485
R 12-20-12



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B.	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
		SHEET 5 OF 7
		REV. B